Date:

Tuesday, 22/04/2008 3:53:35 PM

Üser:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Estimate Number

Job Number : 38761 : 12723

P.O. Number

This Issue

: 22/04/2008

: NC

: 11 : 38564

Type

: SMALL /MED FAB

Part Number

Drawing Name

: D353613 : D3536 REV A

: GASKET

Drawing Number Project Number

: N/A

Drawing Revision

Material

Due Date

: 02/05/2008

Qty:

20 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By Comment

S.O. No. :

: Est Rev:A

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 MNEO60S063

NEOPRENE SHEET 0.063



Comment: Qty.:

0.8682 sf(s)/Unit Total: 17.3649 sf(s)

NEOPRENE SHEET 0.063

Batch: 107655

WATER JET 2.0



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

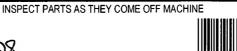
Dwg Rev:__ Prog Rev:_

图 8-4-38

2-Deburr if necessary

3.0

QC2



4.0

QC8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1



5.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stoot

Location:_

Dart Aerospace

W/O:			WORK ORI	DER CHANGES			· ·		
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		(+)							

Part No:	PAR #:	Fault Category:	NCR: Yes N	o DQA:	Date:
			QA: N/C	Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	Approval	Annroval		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
:									
			- 4		*				
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Chief Eng Chi	STEP Description of NC Section A Chief Eng Chi	STEP Description of NC Section A Initial Chief Eng Chief		

NOTE: Date & initial all entries

Date:

Tuesday, 22/04/2008 3:53:35 PM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 38761

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/30/

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-29.

Dart Aerospace Ltd

W/O:			WOR	K ORDER CHANG	ES				
DATE	STEP	PROC	EDURE CHANG	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
*									
Part No	:	PAR #:	_ Fault Categor	y:	NCR: Yes	No DQA:	ř.	Date:	
		•			QA: N	C Closed:		Date:	
NCR:		W	ORK ORDER	NON-CONFORMA	NCE (NCR)			
		Description of NC	Corrective Action Section B			Verification Approv			Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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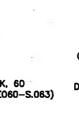
NOTE: Date & initial all entries

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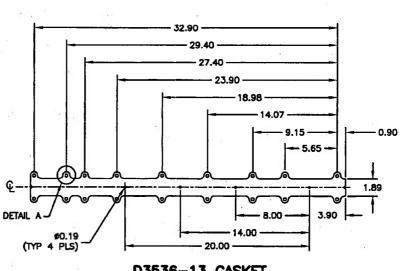
26.65 21.15 17.65 9.15 0.90 - 5.65 1.89 3.90 DETAIL A ø0.19 (TYP 3 PLS) 14.00 D3536-11 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING SHOP COPY RETURN TO



- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

 CB	CB	DART	AEROSPACE USA, INC.	SA, INC.
CHECKED	APPROVED /	DRAWING NO.		REV. A
3	*	D3536		SHEET 1 OF 8
DATE		JULE 3		SCALE
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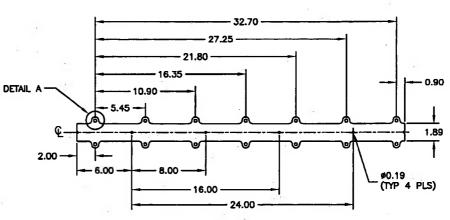
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35.65 33.65 30.15 24.90 19.65 0.90 - 5.65 8.00 3.90 Ø0.19 (TYP 4 PLS) DETAIL A 24.00 D3536-15 GASKET UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING **SHOP COPY** RETURN TO

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

2) FINISH: NONE 3) PART IS SYMM



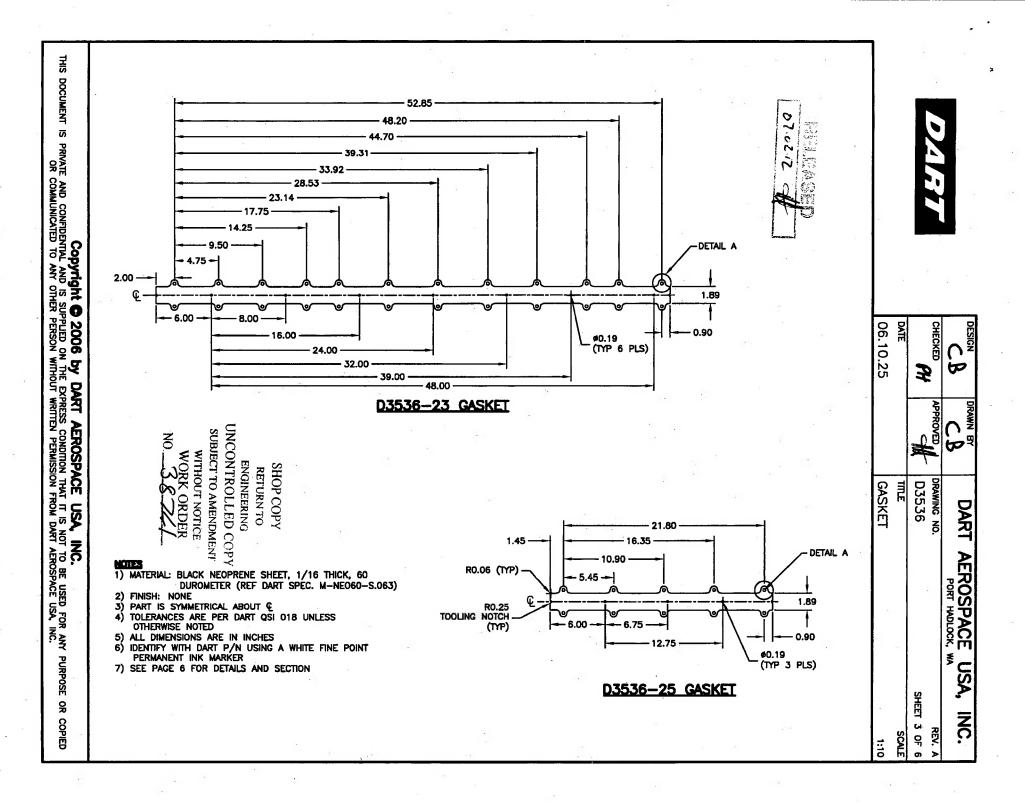
D3536-21 GASKET

CB CB	C B	DART AEROSPACE USA, INC.
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Z	4	D3536 SHEET 2 OF 6
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4 OF 6 REV.

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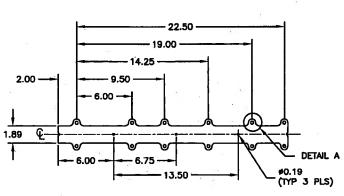
AEROSPACE PORT HADLOCK,

USA,

NC.

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D3536-31 GASKET

ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WORK ORDER WITHOUT NOTICE SHOP COPY RETURN TO

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- DUROMETER (REF DART SPEC. M—NEOSO—S

 2) FINISH: NONE

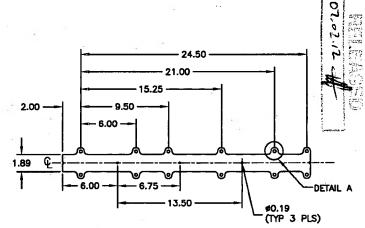
 3) PART IS SYMMETRICAL ABOUT €

 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED

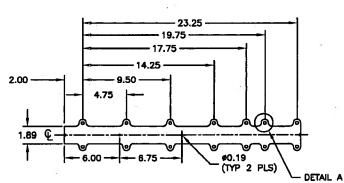
 5) ALL DIMENSIONS ARE IN INCHES

 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER

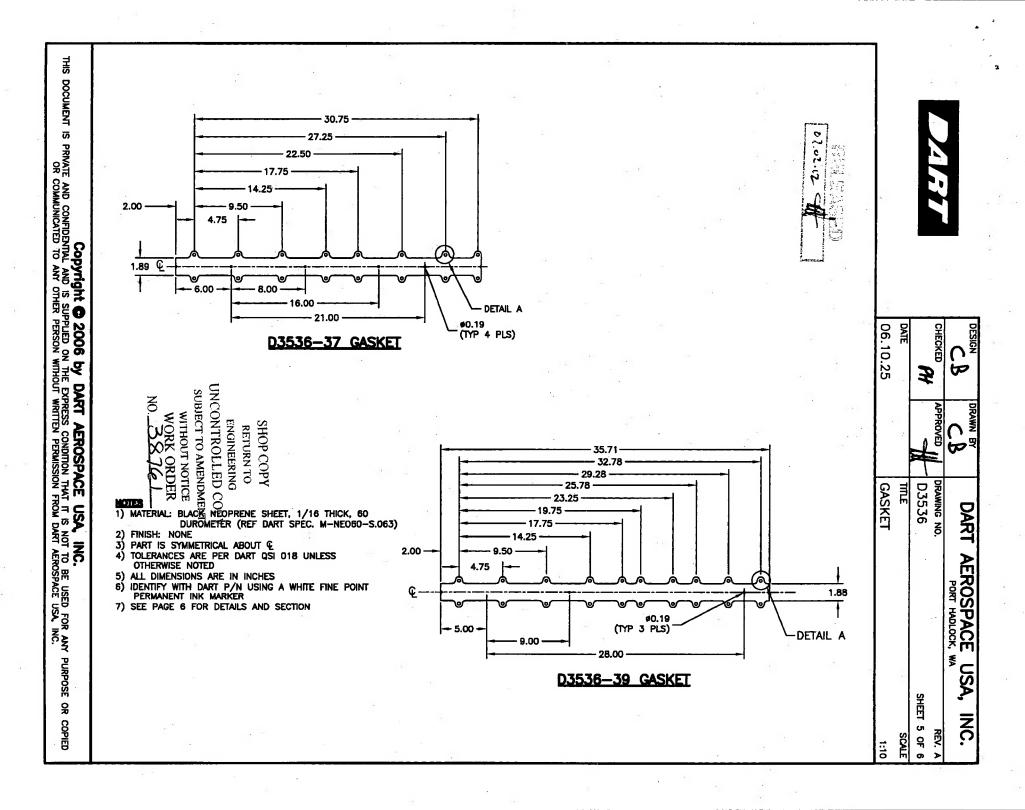
 2) SEE BACE 6. END DETAILS AND SECTION
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



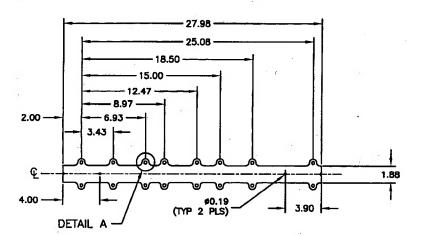
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6.75 (TYP 2 PLS) DETAIL	LA			
)3536-35 GASKET				
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D3536-41 GASKET

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDERS

1) MATERIAL BEACK NEOPRENE SHEET, 1/16 THICK, 60

DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

2) FINISH: NONE

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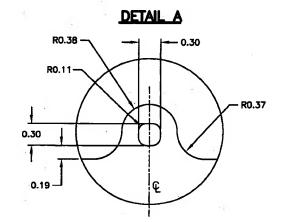
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PURPOSE

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2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER



CHECKED	APPROVED A	DART A	DART AEROSPACE USA, INC.	, ASD,	
#	#	D3536	٠	SHE	SHEET 6 OF
DATE	-	TIME .			SCALE
06.10.25		GASKET			1:10

DART AEROSPACE	LTD	Work Order:	38761
Description: 6	SKET	Part Number:	D3536-13
Inspection Dwg:D353	-Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	
Ø .19	1,005001	. 19	*		·	
.30 x 30	1- 120	30x.30	*			
.90	1/030	.90	*			
1.89	11- 030	1.895	×			
3.90	1/030	3.905	X	<u> </u>		
8.00	4- 030	8.00	×			
14.00	1/038	14.00	×			
	4- :038	00.06	*			
23.2	41- 630	5.65	*			(4)
9.15	1030	9.15	*			
	+1_ 030	14.07	*			
	1/- 630	18.98	*	 		
23.90	1/630	23.90	*			•
	th .030	27.40	*			
V 19	+030		*			
39.90	7030	33.98	* .			
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Measured by: 🗷	Audited by:	5.	Prototype Approval:	M	
Date: 9-428	Date:	08/u/28	Date:		7

Rev	Date	Change		Revised by	Approved
A	7.	New Issue		KJ/JLM	

